

Plate Joiner

(Model 32-100)



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SAFETY RULES

As with all machinery there are certain hazards involved with operation and use of the machine. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

This machine was designed for certain applications only. Delta Machinery strongly recommends that this machine NOT be modified and/or used for any application other than for which it was designed. If you have any questions relative to its application DO NOT use the machine until you have written Delta Machinery and we have advised you.

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WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

- 1. FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE TOOL.** Learn the tool's application and limitations as well as the specific hazards peculiar to it.
- 2. KEEP GUARDS IN PLACE** and in working order.
- 3. ALWAYS WEAR EYE PROTECTION.**
- 4. GROUND ALL TOOLS.** If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter lug must be attached to a known ground. Never remove the third prong.
- 5. REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it "on."
- 6. KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- 7. DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well-lighted.
- 8. KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.
- 9. MAKE WORKSHOP CHILDPROOF** - with padlocks, master switches, or by removing starter keys.
- 10. DON'T FORCE TOOL.** It will do the job better and be safer at the rate for which it was designed.
- 11. USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.
- 12. WEAR PROPER APPAREL.** No loose clothing, gloves, neckties, rings, bracelets, or other jewelry to get caught in moving parts. Nonslip foot wear is recommended. Wear protective hair covering to contain long hair.
- 13. ALWAYS USE SAFETY GLASSES.** Wear safety glasses (must comply with ANSI Z87.1). Everyday eyeglasses only have impact resistant lenses; they are not safety glasses. Also use face or dust mask if cutting operation is dusty.
- 14. SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.
- 15. DON'T OVERREACH.** Keep proper footing and balance at all times.
- 16. MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- 17. DISCONNECT TOOLS** before servicing and when changing accessories such as blades, bits, cutters, etc.
- 18. USE RECOMMENDED ACCESSORIES.** The use of improper accessories may cause hazards.
- 19. AVOID ACCIDENTAL STARTING.** Make sure switch is in "OFF" position before plugging in power cord.
- 20. NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is accidentally contacted.
- 21. CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- 22. DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
- 23. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.
- 24. DRUGS, ALCOHOL, MEDICATION.** Do not operate tool while under the influence of drug, alcohol or any medication.
- 25. MAKE SURE TOOL IS DISCONNECTED FROM POWER SUPPLY** while motor is being mounted, connected or reconnected.
- 26. WARNING:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use wood dust collection systems whenever possible.

ADDITIONAL SAFETY RULES FOR PLATE JOINER

1. **WARNING:** Do not operate your machine until it is completely assembled and installed according to the instructions.
2. **IF YOU ARE NOT** thoroughly familiar with the operation of Plate Joiners, obtain advice from your supervisor, instructor or other qualified person.
3. **MAKE CERTAIN** that machine is securely attached to support table before operating.
4. **CHECK** to make sure that cutter blade is securely fastened.
5. **KEEP** fingers out of path of cutting blade.
6. **USE** the adjustable stock stop and dual position work clamp provided to properly secure and control workpiece whenever possible.
7. **ALWAYS** wear eye protection
8. **NEVER** reach behind or over cutting tool with either hand for any reason.
9. **PROVIDE** adequate support to the rear and sides of the work support table for wide or long workpieces.
10. **AVOID** operations and hand positions where a sudden slip could cause your hand to move into the cutting tool.
11. **NEVER** perform layout, assembly or set-up work on the table while the machine is operating.
12. **ALWAYS** turn the machine "OFF" and disconnect the cord from the power source before installing or removing the blade.
13. **NEVER** leave the machine work area when the power is "ON" or before the machine has come to a complete stop.

ASSEMBLY INSTRUCTIONS

ASSEMBLING TABLE

1. Place the motor and fence assembly (A) Fig. 2, on a flat supporting surface or workbench, as shown.
2. Position table (B) Fig. 2, so guide (C) will rest inside channel (D) of fence.

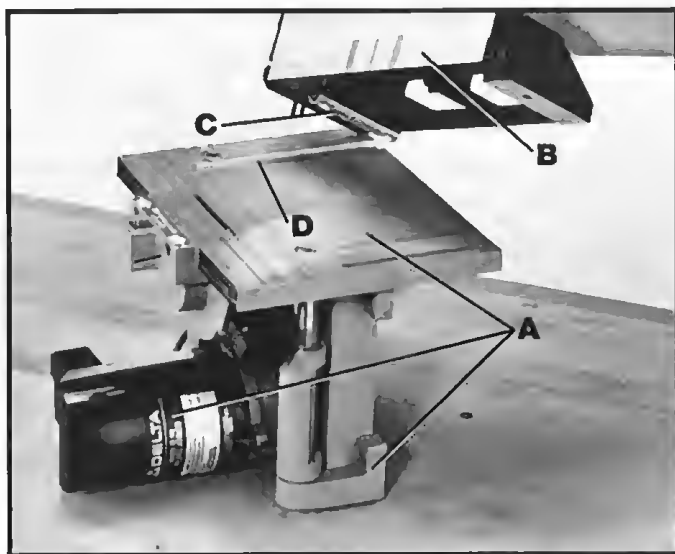


Fig. 2

3. Locate the two table locking handle assemblies, shown in Fig. 3.

4. Remove screw (A) Fig. 3, spring (B) and handle (C) from shaft assembly (D).

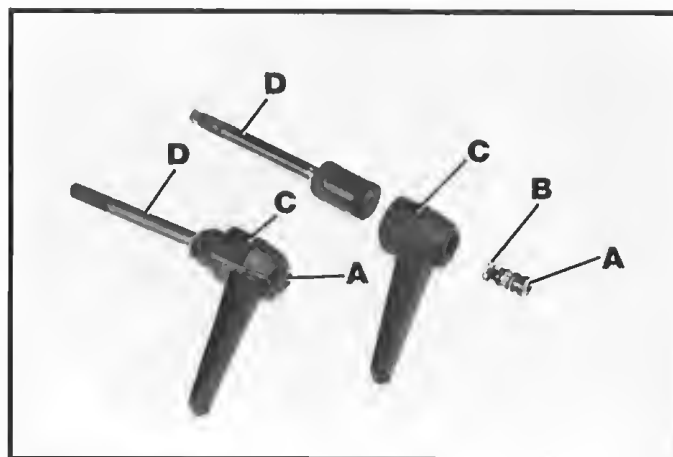


Fig. 3

5. Place flat washer (E) Fig. 4, on shaft assembly (D) and insert threaded portion of shaft assembly (D) through holes in table and fence, as shown.

6. Place square nut (F) Fig. 4, in position in channel in back of fence (G) and thread shaft assembly (D) into nut (F). **NOTE: ROUNDED SIDE OF NUT (F) SHOULD BE AGAINST FENCE AND FLAT SIDE OF NUT (F) SHOULD BE TOWARD THE OUTSIDE.**

7. Assemble the remaining shaft assembly in the same manner.

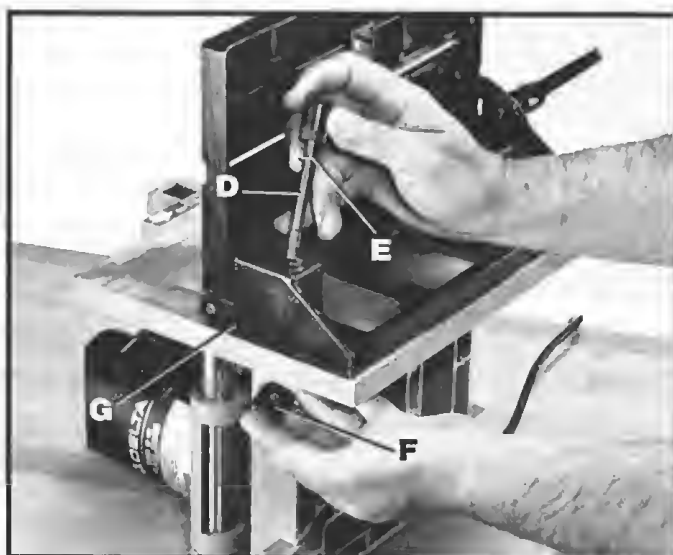


Fig. 4

8. Replace the locking handles (C) Fig. 5, spring and screw (A) to shaft assemblies. These items were removed in **STEP 4**. Tighten handles (C) to lock the table in position. **IMPORTANT: WHEN TIGHTENING TABLE LOCK HANDLES (C) ALWAYS TIGHTEN THE RIGHT HAND HANDLE FIRST TO INSURE TABLE IS LEVEL ON BOTH SIDES. NOTE:** Lock handles (C) are spring loaded and can be repositioned by pulling out on the handle and repositioning it on the serrated nut located underneath the hub of the handle.

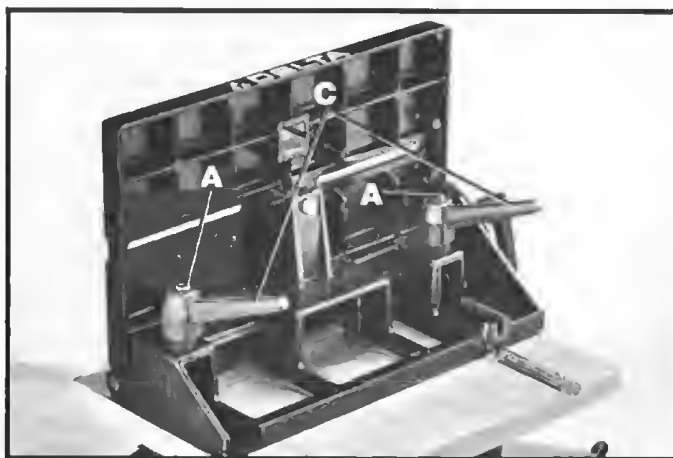


Fig. 5

ASSEMBLING MICRO-SET TABLE ADJUSTER

1. Make sure top of screw (A) Fig. 6, is engaged with bracket (B) and insert bracket assembly (C) in channel (D). Fasten bracket assembly (C) to fence (E) using screw (F) and washer (G). Do not tighten screw (F). Turn knob (H) until bracket (C) is down as far as possible in channel (D) and tighten screw (F).

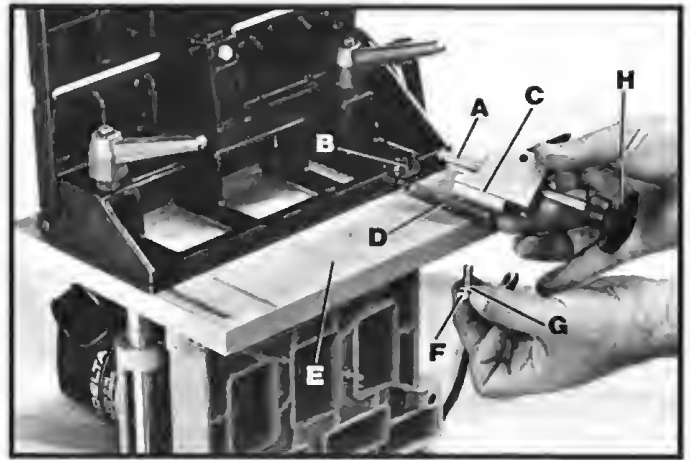


Fig. 6

2. Fig. 7, illustrates the micro-set table adjuster correctly assembled to the table and fence.



Fig. 7

3. Position machine so it rests over edge of the supporting surface, as shown in Fig. 8.

4. **IMPORTANT: TO AVOID PERSONAL INJURY OR DAMAGE TO THE MACHINE, WE STRONGLY SUGGEST THAT THE MACHINE BE FASTENED TO THE SUPPORTING SURFACE DURING THE REST OF THE ASSEMBLY PROCEDURE USING CLAMPS OR FASTENERS.**

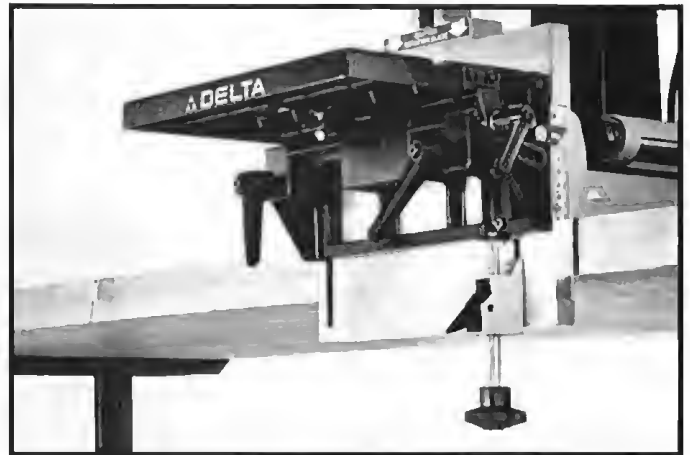


Fig. 8

POSITIONING SAFETY GUARD ON FOOT PEDAL

1. Lift up and rotate guard (A) Fig. 9, until hole in guard lines up with hole (B) in foot pedal assembly. Fasten guard (A) in place with lockwasher (C) and threaded lock knob (D).

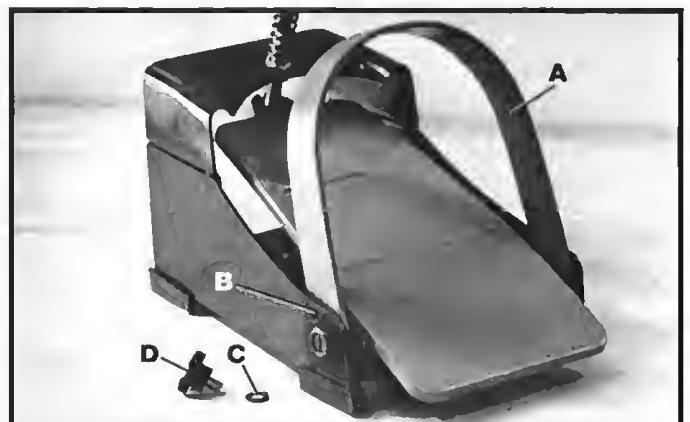


Fig. 9

ASSEMBLING CABLE ASSEMBLY

The cable assembly (A) Fig. 10, is shipped from the factory with one end of the cable assembled to the foot pedal. The free end, however, must be mounted to the rear of the machine, as follows:

1. Insert the cable assembly (A) Fig. 10, thru hole in casting and fasten using hex nut (B) supplied. **NOTE:** Hex nut (C) was threaded onto cable assemble at the factory.

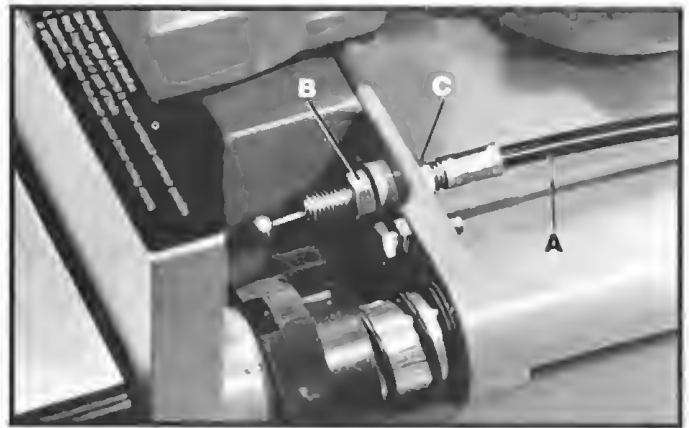


Fig. 10

2. Position cable shield (D) Fig. 11, over cable and insert end of cable (E) into slotted bracket (F). **NOTE:** If end of cable (E) does not reach slotted bracket (F) it will be necessary to tighten and/or loosen the two nuts (B) and (C).

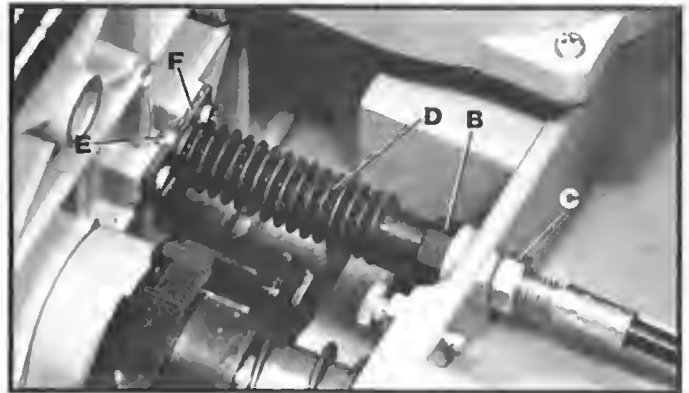


Fig. 11

ASSEMBLING ADJUSTABLE STOCK STOP TO TABLE

1. When using the adjustable stock stop, place bar (A) Fig. 12, in groove (B) of table. Fasten the bar to the table using lock knob (C) and washer (D). Thread lock knob (C) up through one of the slots in the table groove and into one of the two threaded holes (E) in bar.

2. The adjustable stock stop can be used in the right hand position, as shown in Fig. 13, or in the left hand position, as shown in Fig. 14.

3. To rotate the stock stop body (E) Fig. 13 and 14, for angles, simply loosen lock handle (F), rotate body (E) to the angle of the workpiece. Then tighten handle (F).

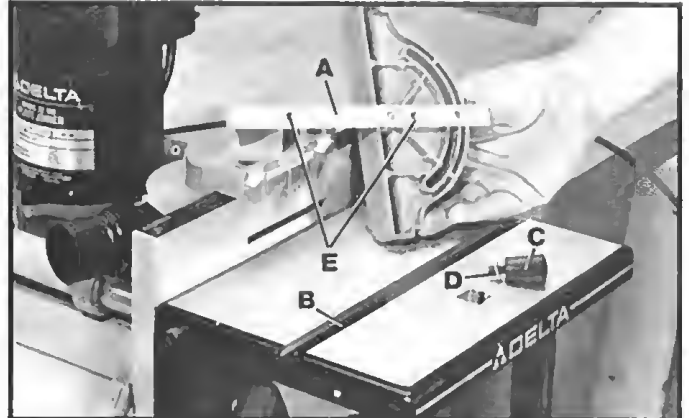


Fig. 12

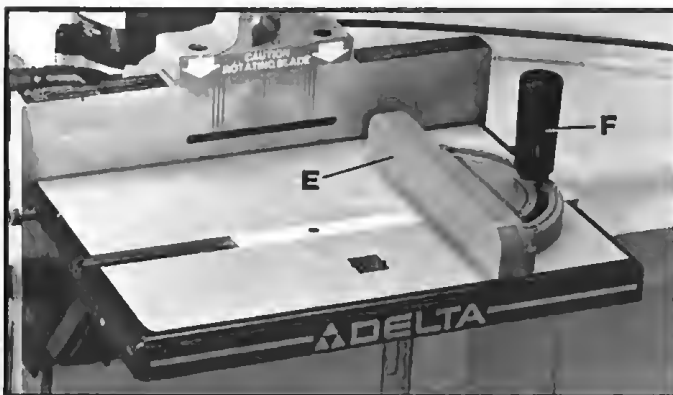


Fig. 13

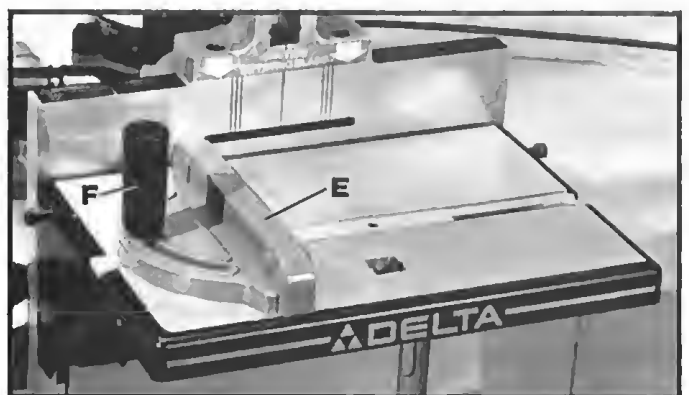


Fig. 14

DUAL POSITION WORK CLAMP

The dual position work clamp can be used in the vertical position, as shown in Fig. 15, or in the horizontal position, as shown in Fig. 16.

To instantly position the clamp (A) Fig. 15 and Fig. 16, against the workpiece, simply turn the handle (B) counter-clockwise one-half turn and rapidly slide the threaded shaft (C) until the clamp (A) is against the work. Then tighten the clamp (A) by turning the handle (B) clockwise.

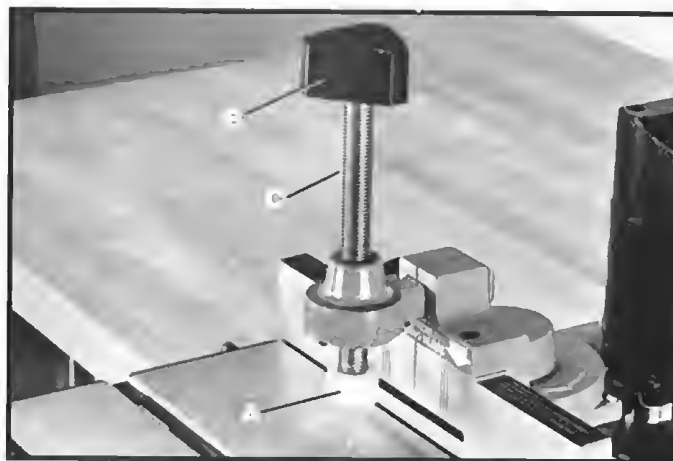


Fig. 15

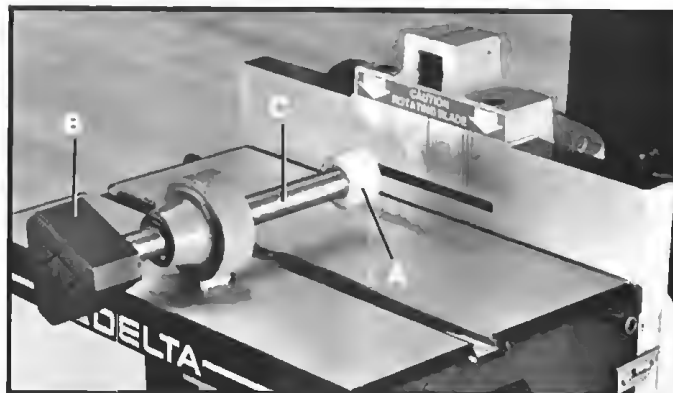


Fig. 16

DUST CHUTE

A dust chute (A) is supplied for use with your plate joiner and is to be assembled to the chip exhaust (B) on the left rear side of the machine, as shown in Fig. 17. The plate joiner can be connected directly to the Delta accessory 49-255 28-gallon, all purpose vacuum cleaner by removing the dust chute (A) Fig. 17, and using the accessory 49-220 (2 1/2" x 1 1/2") adapter and the accessory 49-228 (2 1/2" x 2 1/2") coupling. The hose from the 49-255 vacuum cleaner can then be connected to the coupling.



Fig. 17

FASTENING MACHINE TO SUPPORTING SURFACE

The plate joiner must always be fastened to a supporting surface using clamps or by using bolts through the four mounting holes in the machine base. Two of the mounting bolts are shown at (A) Fig. 18.

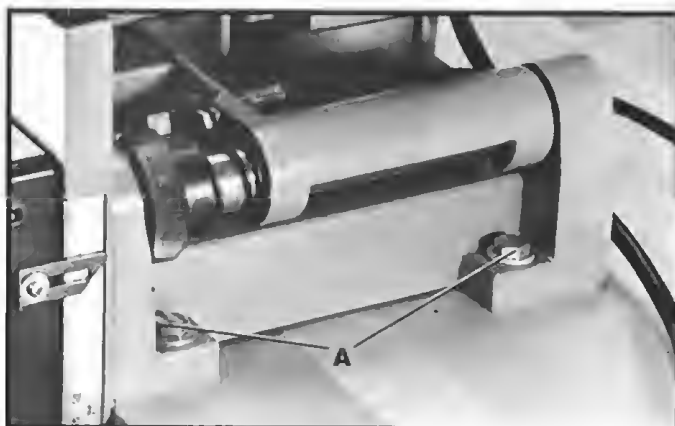


Fig. 18

CONNECTING PLATE JOINER TO POWER SOURCE

POWER CONNECTIONS

A separate electrical circuit should be used for your tools. This circuit should not be less than #12 wire and should be protected with a 20 Amp time lag fuse. If an extension cord is used, use only 3-wire extension cords which have 3-prong grounding type plugs and 3-pole receptacles which accept the tools plug. For distances up to 100 feet use #12 wire. For distances up to 150 feet use #10 wire. Have a certified electrician replace or repair damaged or worn cord immediately. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as stamped on motor nameplate. All line connections should make good contact. Running on low voltage will damage the motor.

GROUNDING INSTRUCTIONS

CAUTION: THIS TOOL MUST BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding type plugs and 3-hole receptacles that accept the tool's plug, as shown in Fig. 19.

Repair or replace damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet and a plug that looks like the one shown in Fig. 19. A temporary adapter, which looks like the adapter illustrated in Fig. 20, may be used to connect this plug to a 2-pole receptacle, as shown in Fig. 20, if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. **THIS ADAPTER IS NOT APPLICABLE IN CANADA.** The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground, such as properly grounded outlet box, as shown in Fig. 20.

CAUTION: IN ALL CASES, MAKE CERTAIN THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED. IF YOU ARE NOT SURE HAVE A CERTIFIED ELECTRICIAN CHECK THE RECEPTACLE.

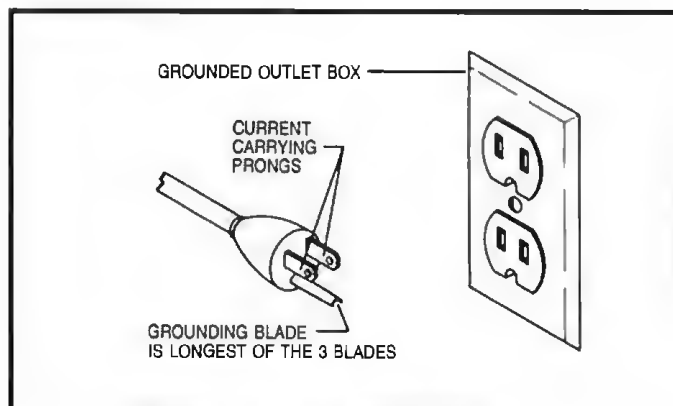


Fig. 19

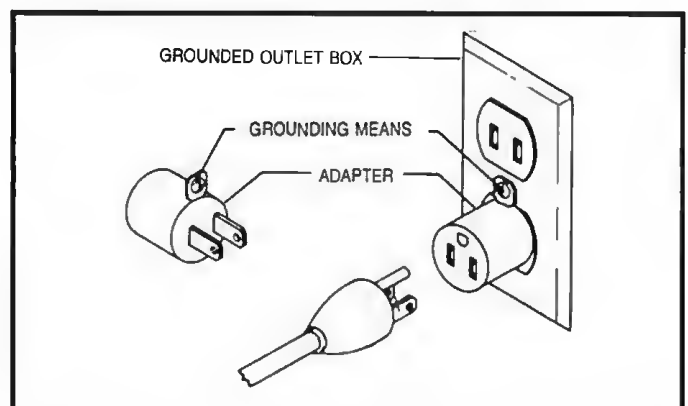


Fig. 20

OPERATING CONTROLS AND ADJUSTMENTS

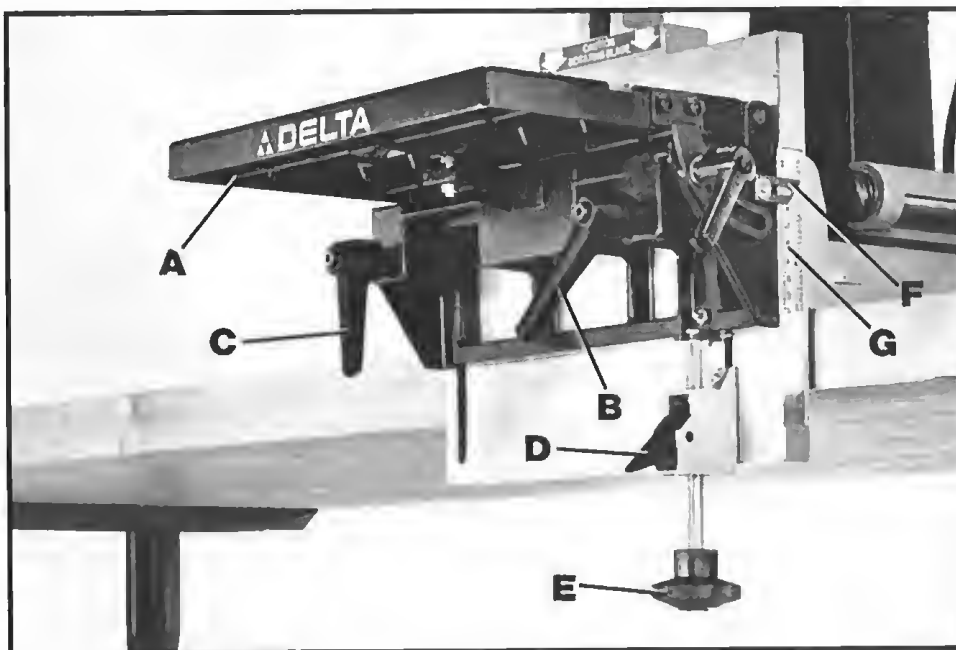


Fig. 21

RAISING AND LOWERING TABLE

1. To raise the table (A) Fig. 21, loosen the two table lock levers (B) and (C), manually raise table (A) to the desired height and tighten lock levers (B) and (C). **IMPORTANT: WHEN TIGHTENING LOCK LEVERS (B) AND (C), ALWAYS TIGHTEN LEVER (B) FIRST TO ENSURE TABLE WILL BE LEVEL ON BOTH SIDES.**
2. To lower the table (A) Fig. 21, loosen table lock levers (B) and (C) and while holding table (A) depress spring clip (D) and lower table to the desired setting. Then tighten lock levers (B) and (C). **IMPORTANT: WHEN TIGHTENING LOCK LEVERS (B) AND (C), ALWAYS TIGHTEN LEVER (B) FIRST TO ENSURE TABLE WILL BE LEVEL ON BOTH SIDES.**
3. For fine adjustments to the table setting, loosen table lock levers (B) and (C) Fig. 21, and turn Micro-Set adjustment knob (E) clockwise to raise or counterclockwise to lower the table. Tighten lock levers (B) and (C). **IMPORTANT: WHEN TIGHTENING LOCK LEVERS (B) AND (C), ALWAYS TIGHTEN LEVER (B) FIRST TO ENSURE TABLE WILL BE LEVEL ON BOTH SIDES.**
4. The distance the table surface is positioned below the bottom of the cutter is determined by the pointer (F) Fig. 21, on the dual english/metric scale (G). If an adjustment to the pointer (F) is necessary, loosen screw and adjust pointer accordingly.

TILTING THE TABLE

The table on your machine can be tilted to accommodate workpieces with beveled edges by loosening handle (A) Fig. 22, tilting the table (B) to the desired angle and tightening handle (A). **NOTE:** Handle (A) is spring loaded and can be repositioned by pulling out on the handle and repositioning it on the nut located underneath the hub of the handle.

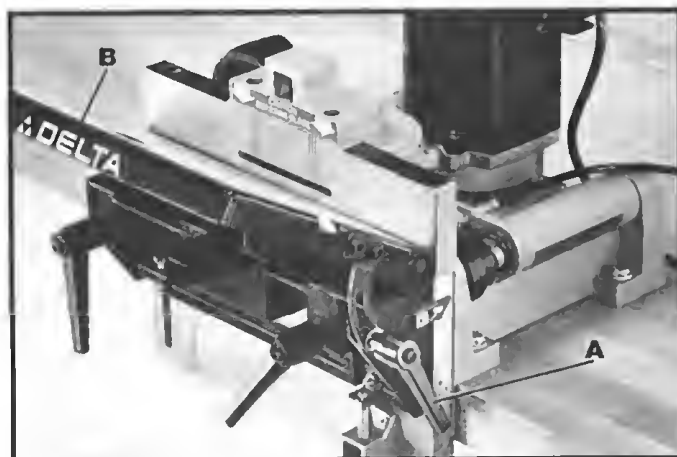


Fig. 22

ADJUSTING TABLE 90 DEGREES TO FENCE

1. Loosen table lock handle (A) Fig. 23, make sure the table is all the way down and tighten lock handle (A).
2. Using a square (B) Fig. 23, check to see if the table is 90 degrees to the fence, as shown.

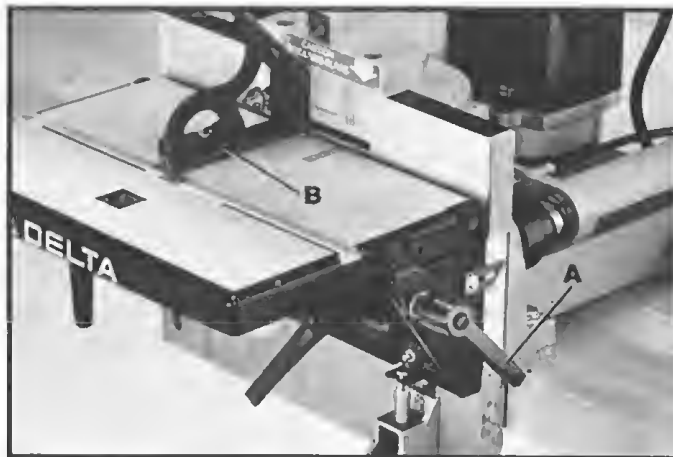


Fig. 23

3. If the table is not at 90 degrees to the fence, adjust the table accordingly making certain screw (C) Fig. 24, contacts bottom of table when the table is at 90 degrees to the fence. Screw (C) can be adjusted by loosening nut (D), turning screw (C) in or out the desired amount and tightening nut (D). This positive stop enables you to rapidly return the table to the 90 degree position after it has been tilted.

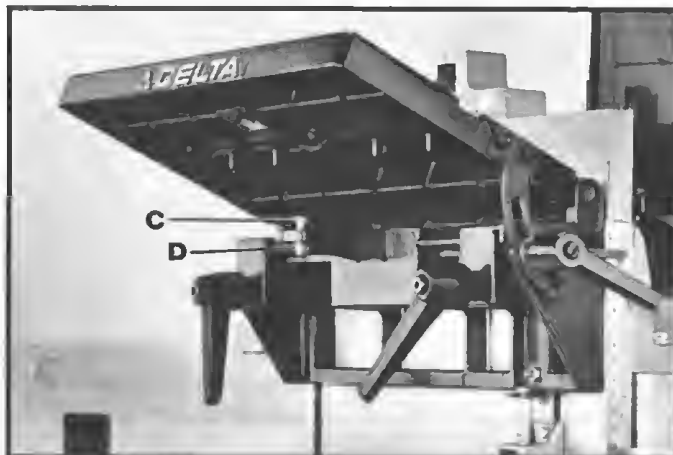


Fig. 24

STARTING AND STOPPING MACHINE

The on/off switch (A) Fig. 25, is located on the side of the motor. To turn the plate joiner "ON," move the toggle switch (A) toward the front. To turn the machine off, push the switch (A) toward the rear.

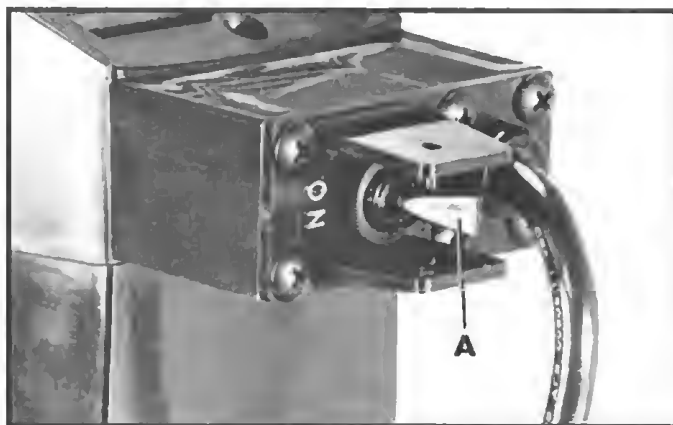


Fig. 25

LOCKING SWITCH IN THE "OFF" POSITION

We suggest when the machine is not in use, the switch (A) be locked in the "OFF" position with a padlock, as shown in Fig. 26.

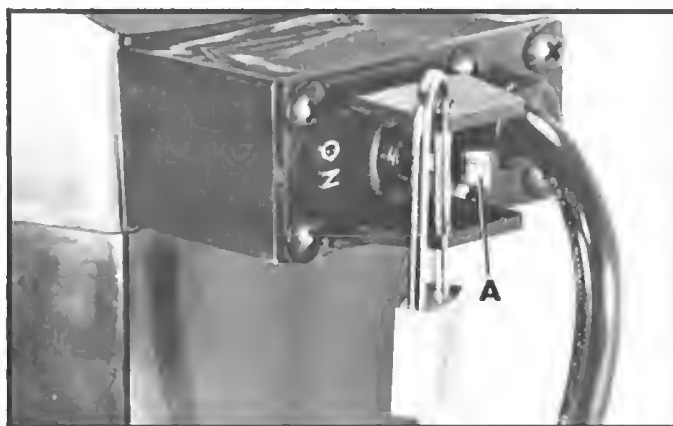


Fig. 26

DEPTH OF CUT CONTROL

The Delta Plate Joiner has the capability of cutting slots in wood to accommodate three biscuit sizes, 0, 10 and 20, as shown in Fig. 27.

The lines (A), (B) and (C) Fig. 27, on the fence and table, indicate the width of cut for each biscuit size:

- (A) - For size "0" biscuit
- (B) - For size "10" biscuit
- (C) - For size "20" biscuit

Line (D) Fig. 27, indicates the center line of the cut to be made for size "0", "10" and "20" biscuits.

To adjust the depth of cut for different size biscuits rotate dial (E) Fig. 28, until the pointer (F) is pointing to the desired size of slot you wish to cut, for either "0", "10" or "20" biscuit.

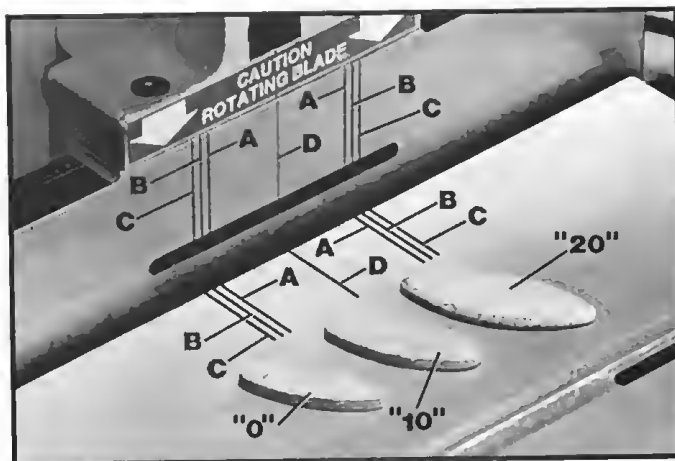


Fig. 27



Fig. 28

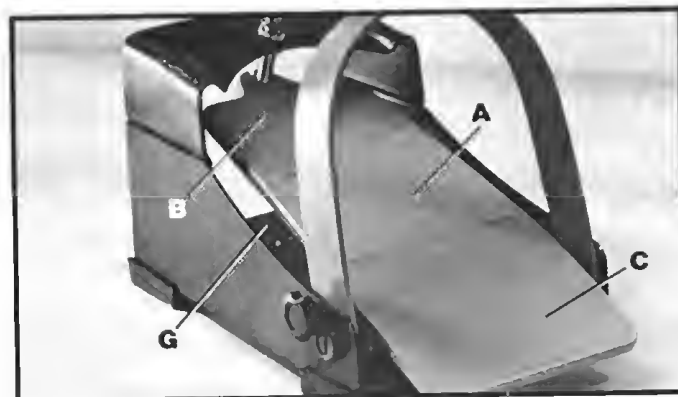


Fig. 29

CHECKING AND ADJUSTING DEPTH OF CUT

1. Rotate dial (E) Fig. 28, until the pointer (F) is pointing to the desired size of slot you wish to cut. **NOTE:** In this case we will be making a test cut for a size "0" biscuit.
2. Make a test cut in a scrap piece of wood.
3. Insert a size "0" biscuit in the cut just made. The biscuit should enter the wood slightly more than halfway before it bottoms in the cut.
4. If the slot is too deep or not deep enough adjust the depth of cut by loosening nut (G) Fig. 28, and tightening or loosening screw (H). Continue to make test cuts until the depth of cut is as stated in **STEP 3**. Then tighten nut (G).

FOOT PEDAL

The Foot Pedal (A) Fig. 29, controls the lateral movement of the biscuit cutter. Pressing down on the pedal (A) moves the cutter out to make the cut and releasing pedal (A) retracts the cutter.

ADJUSTING FOOT PEDAL CABLE

When the foot pedal (A) Fig. 29, is depressed the bracket (D) Fig. 30, moves forward until the adjusting screw (E) contacts stop (F). When the machine is in this position (cutter exposed on the front of the fence) the boss located directly underneath the top of the foot pedal (B) Fig. 29, should be between 1/4 and 1/2 inch away from bottoming on bottom plate (G) Fig. 29. If it is not, an adjustment to the cable can be made by sliding back sleeve (H) Fig. 30, and adjusting the cable by tightening and loosening the two adjusting nuts (J) and (K) Fig. 30.

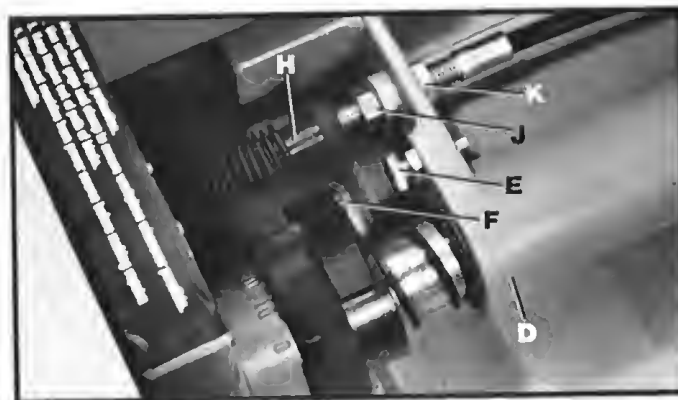


Fig. 30

REPLACING CUTTER

When it becomes necessary to replace the cutter on your plate joiner, proceed as follows:

1. **MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.**

2. Remove five screws (A) Fig. 31, and top cutter guard (B).

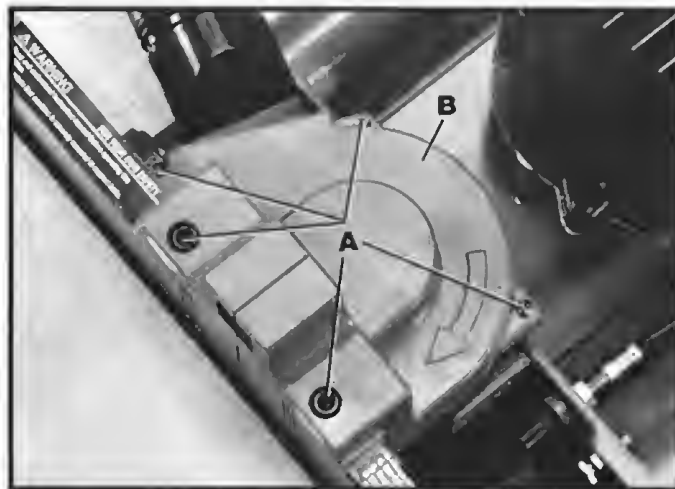


Fig. 31

3. Place open end wrench on flats (C) Fig. 32, of cutter arbor, to keep the arbor from turning, and remove arbor nut (D), flange (E) and cutter (F). **NOTE:** Turn arbor nut (D) clockwise to remove.

4. Assemble new cutter making certain the teeth of the cutter point to the right when looking straight down on the cutter and replace flange (E) and arbor nut (D) Fig. 32. **NOTE:** Turn arbor nut counterclockwise to tighten while holding flats (C) of arbor with wrench to keep arbor from turning.

5. Replace cutter guard which was removed in **STEP 2**.

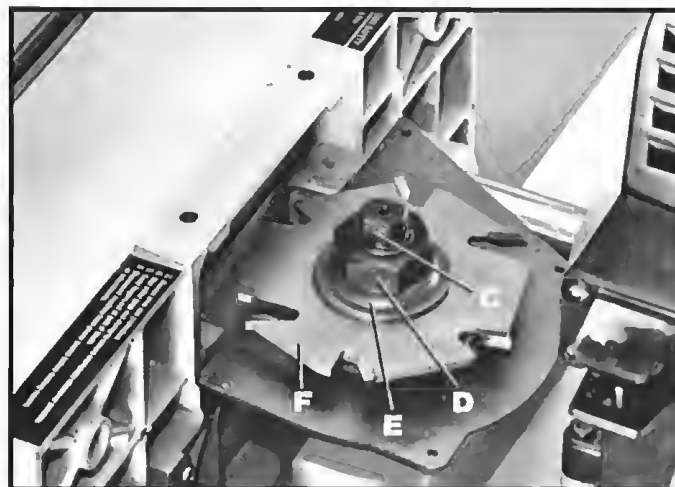


Fig. 32

SOME TYPICAL OPERATIONS

The following are just a few examples of some of the many operations that can be performed with your Delta Plate Joiner. All operators will profit by a knowledge of how these operations can be performed and we suggest you study these examples before turning on the power.

EDGE JOINING

1. Mark the two boards to be edge joined together at the points where the biscuits are to be placed, as shown at (A) Fig. 33. These marks indicate the center of the biscuit cut and should be on the opposite surface of the boards you want perfectly matched. If boards are of different thickness, be sure the "good" or face side of the boards are "down."

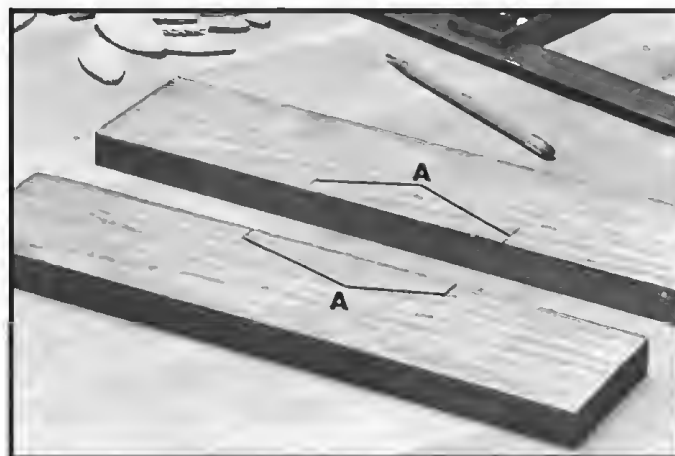


Fig. 33

2. Adjust the height of the table and line up one of the points marked in **STEP 1**, with the center line of the cutter, as shown in Fig. 34, and cut the first biscuit slot. Note the dual position work clamp (B) being used to firmly hold the workpiece on the table. Cut biscuit slots at the remaining three positions that were marked in **STEP 1**.

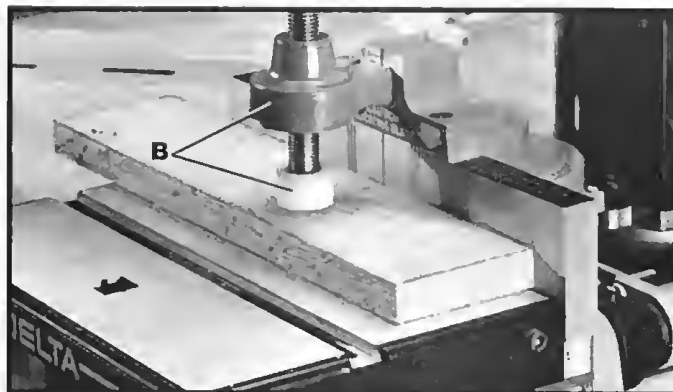


Fig. 34

3. Apply glue to inside of biscuit slots and insert biscuits (C) into two of the slots, as shown in Fig. 35. Then press the two pieces of wood together.

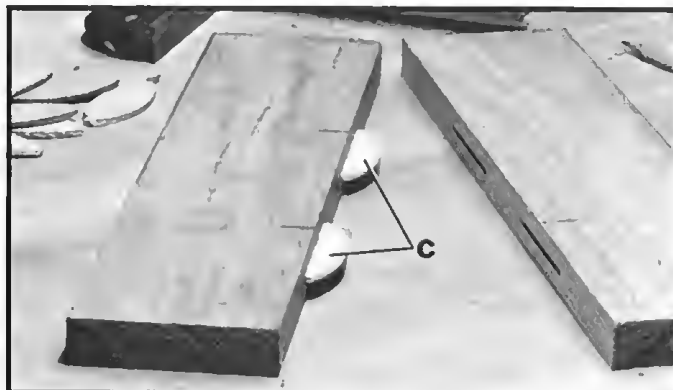


Fig. 35

BEVEL EDGE JOINING

1. Mark the two boards to be bevel edge joined together at the points where the biscuits are to be placed, as shown at (A) Fig. 36. These marks indicate the center of the biscuit cut and should be on the opposite surface of the boards you want perfectly matched.

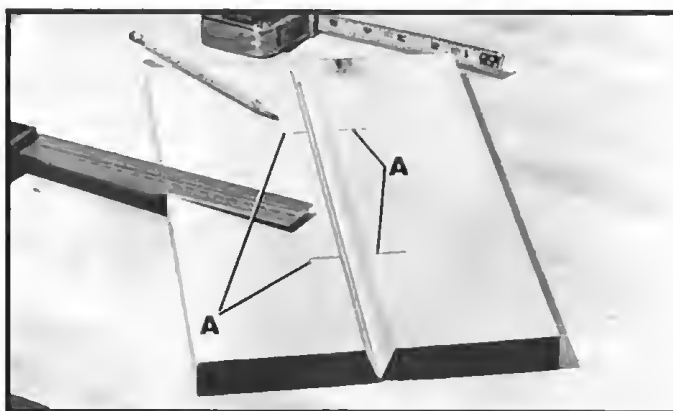


Fig. 36

2. Adjust the angle of the tilting table (B) to match the angle of the workpiece, as shown in Fig. 37. Adjust the height of the table to position biscuit slot at proper location in beveled surface. Line up one of the points marked in **STEP 1**, with the center line of the cutter, and cut the first biscuit slot, as shown. Cut biscuit slots at the remaining three positions that were marked in **STEP 1**.



Fig. 37

3. Apply glue to the inside of biscuit slots and insert biscuits (C) into two of the slots as shown in Fig. 38.

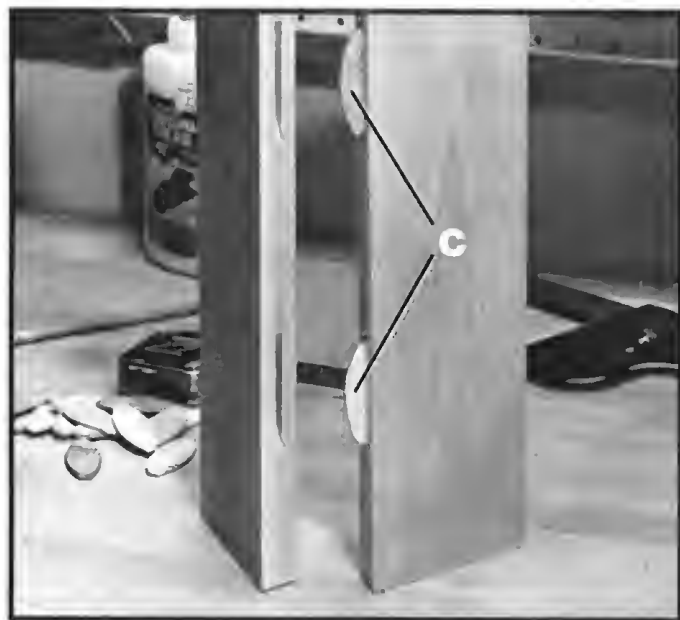


Fig. 38

4. Press the two pieces of wood together as shown in Fig. 39.

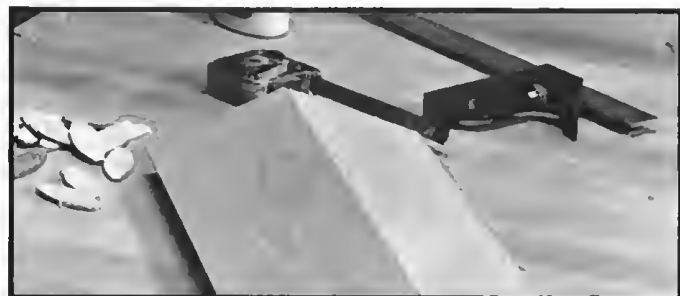


Fig. 39

BEVEL END JOINING

1. Mark the two boards to be bevel end joined together at the points where the biscuit is to be placed, as shown at (A) Fig. 40. These marks indicate the center of the biscuit cut and should be on the opposite surface of the boards you want perfectly matched.

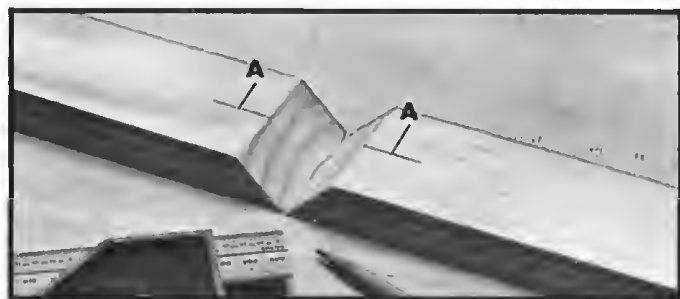


Fig. 40

2. Adjust the angle of the tilting table to match the angle of the workpiece, as shown in Fig. 41. Line up one of the points marked in **STEP 1** with the center line of the cutter and cut the first biscuit slot. **NOTE:** A back-up stop block (B) is clamped to the tilting table to support the workpiece. Cut the biscuit slot at the remaining position marked in **STEP 1**.

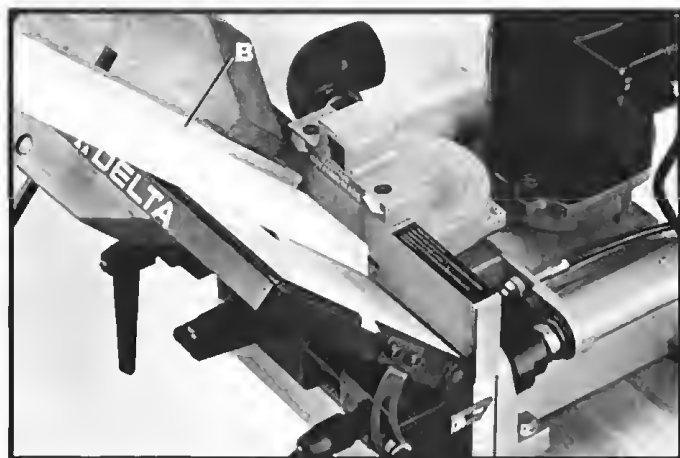


Fig. 41

3. Apply glue to the inside of biscuit slots, insert biscuit and press the two pieces of wood together, as shown in Fig. 42.



Fig. 42

BUTT JOINING

1. Mark the two boards to be butt joined together at the points where the biscuit is to be placed, as shown at (A) and (B) Fig. 43. These marks indicate the center of the biscuit cut. Make sure the marks (A) and (B) are on the inside surface of the boards as shown. **NOTE:** On the vertical piece the line (B) must extend higher, as shown.

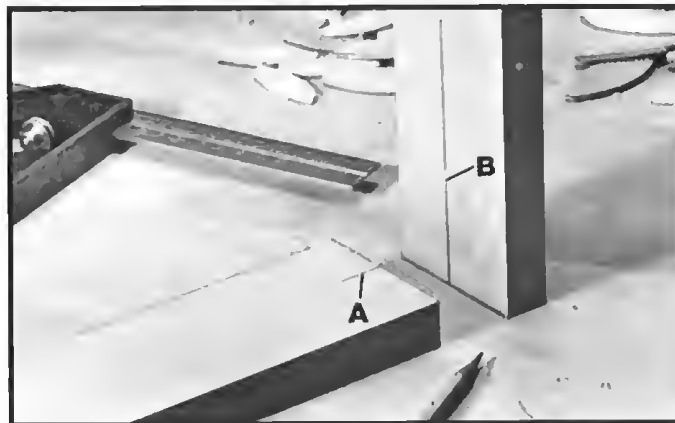


Fig. 43

2. Line up the point marked at (A) in **STEP 1** of the horizontal piece with the center line of the cutter and cut the first biscuit slot, as shown in Fig. 44. Note the dual position work clamp (C) and the adjustable stock stop (D) being used to hold and position the workpiece.

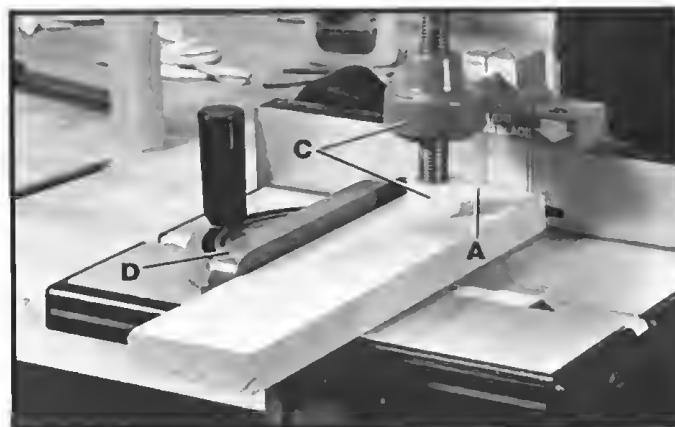


Fig. 44

3. Line up the point marked at (B) in **STEP 1** on the vertical piece with the center line (E) of the cutter and cut the second biscuit slot. This line is located on top of the cutter guard, as shown in Fig. 45. Note the dual position work clamp (C) being used to hold the workpiece.

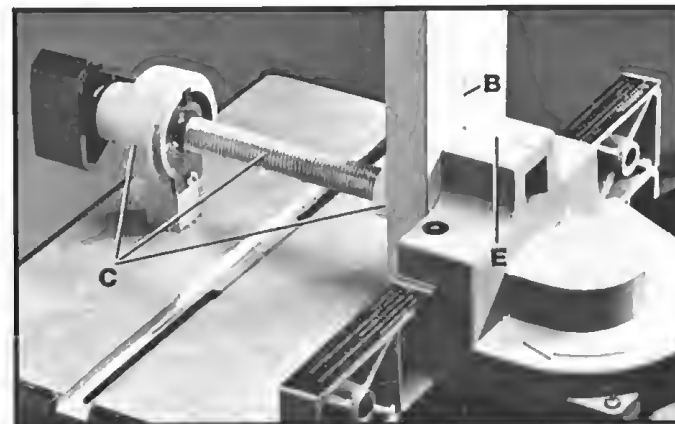


Fig. 45

4. Apply glue to the inside of biscuit slots, insert biscuit (F), as shown in Fig. 46, and press the two pieces of wood together.

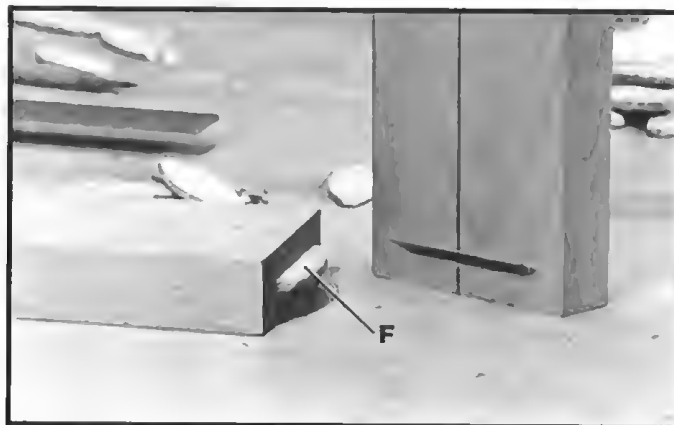


Fig. 46

MITER JOINING

1. Adjust the angle of the stock stop (A) Fig. 47, to conform with the miter angle of the workpiece, center the workpiece over the cutter slot, clamp the stock stop to the table and cut the biscuit slot in the first piece, as shown in Fig. 47. Note that “good” or face side of the board is against the table.



Fig. 47

2. Cut the biscuit slot in the second piece, as shown in Fig. 48, in the same manner as in **STEP 1** with the “good” or face side of the board against the table.



Fig. 48

3. Apply glue to the inside of biscuit slots, insert biscuit and press the two pieces of wood together, as shown in Fig. 49.

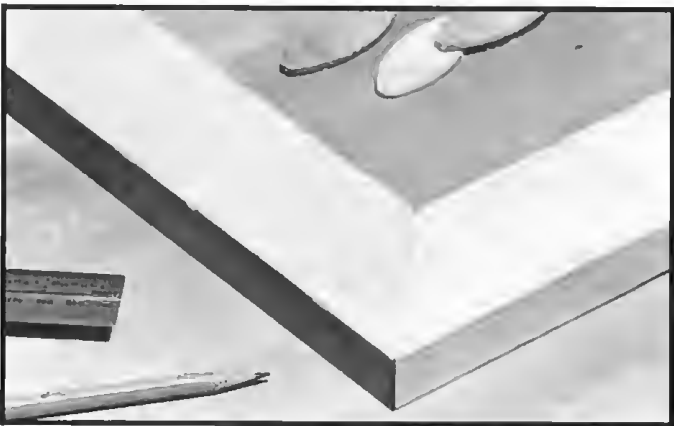


Fig. 49

AUTHORIZED SERVICE STATIONS

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Bucknall Power Tool Service
11910 Vose Street
818-765-0228
Oakland 94606-4389
California Electric Service
1139 E. 12th Street
415-834-1050
Fax: 415-836-1125
Oceanside 92054
Power Source
1555 S. Hill Street
619-433-6600
Pasadena 91107-3785
California Electric Service
2594 E. Colorado Blvd.
818-792-3194
Fax: 818-792-0511
Redding 96002
Electric Tool and Motor
915 Well Street #1
916-222-1131
Sacramento 95814-6784
California Electric Service
1821 "Q" Street
916-443-5711
Fax: 916-443-4082
Sacramento 95814
Construction Industry Service
Company
1211 C Street
916-444-2525
San Carlos 94070-4168
California Electric Service
990 Industrial Road, Suite 102
415-593-6696
Fax: 415-593-6698
San Diego 92104-1593
California Electric Service
3430 El Cajon Blvd.
619-283-6488
Fax: 619-281-3479
San Francisco 94103-4488
California Electric Service
1090 Bryant Street
415-431-8494
Fax: 415-431-9207
San Jose 95126-3154
California Electric Service
783 The Alameda
408-295-1723
Fax: 408-295-8451
San Leandro 94577
Porter-Cable Corporation
3039 Teagarden Street
P.O. Box 1913
415-357-9762
San Marcos 92069
Pro-Tek Tool Repair
215 Pacific Street, #111
619-471-4800
Santa Ana 92707-2850
California Electric Service
2025 S. Main Street
714-641-0629
Fax: 714-641-2947
Santa Rosa 95401
Acme Electric Tool Repair
742 Wilson Street
707-546-5662
Santa Rosa 95403
H & V Tool Repair
1808 Empire Industrial Court #D
707-528-1111
Simi Valley 93065
Simi Tool Repair
1236 Los Angeles Avenue, Unit D
805-584-8138

Temecula 92390-5623
California Electric Service
41715 Enterprise Circle North
Suite 101
714-695-5445
Fax: 714-695-5447
Torrence 90502
Universal Tool Service
21804 S. Vermont Avenue
213-328-8472
Van Nuys 91411-1018
California Electric Service
14753 Oxnerd Street
818-997-8855
Fax: 818-997-3047
Whittier 90602
Balleis Hdw & Tool Co.
13236 E. Whittier Blvd
213-698-3714
W. Los Angeles 90064-2110
California Electric Service
2314 S. Westwood Blvd.
213-475-2532
Fax: 213-475-2844

CDLRDADD
Avon 81620
Tool Clinic
41000 Highway 6
303-949-6282
Colorado Springs 80219
Schlosser Tool and Machinery
3960 Sinton Road
719-636-1311
Denver 80204
Porter-Cable Corporation
2561 West 8th Ave.
303-892-6113
Denver 80219
"Schlosser Tool and Machinery
301 Bryant Street
303-922-8244
Grand Junction 81501
Professional Tool Service, Inc.
124 22nd Ct
303-245-3158

CONNECTICUT
Hartford 06106
Utility Electric Service, Inc.
53 Main Street
203-246-7271
Oakville 06779
Watertown Tool Supply
28 Main Street
203-596-1344
DELAWARE
New Castle 19804
Holloway Bros.
19 E. Commons Blvd.
302-322-5441
"Wilmington 19804
Holloway Bros.
P.O. Box 3055
302-322-5441
FLORIDA
Ft. Lauderdale 33334
Master Repair Inc.
4107 N.E. 6th Avenue
305-566-5833
Ft. Myers 33905
Power Tool Repair of Ft. Myers
9950 Orange River Blvd
813-894-6058
Gainesville 32609
Florida Fastener and Tool Co., Inc.
2826 N. Waldo Road
904-377-4587
Hialeah 33014
Porter-Cable Corporation
18373-75 NW 57th Ave.
305-624-2523
Jacksonville 32205
North Florida Machinery
& Tool Repair
230-B Edgewood Ave. South
904-387-4455
Orlando 32803
Finch's Machinery &
Tool Service Inc.
1807 1/2 Winter Park Road
407-644-8100
Pensacola 32505
L. C. Electric Motor Service
117 Industrial Blvd.
904-476-7655
Riviera Beach 33404
3706 E. Industrial Way
407-848-4320
Tampa 33609
Porter-Cable Corporation
4538 W. Kennedy Blvd
813-877-9585

West Palm Beach 33409
Rogers Engines Inc.
2532 Old Okeechobee Road
407-689-8300
GEORGIA
Augusta 30901
Tool Service Center
Box No. 1488
302 Walton Way
404-724-4803
Morrow 30280
Porter-Cable Corporation
1286C Citizens Parkway
404-961-0900
Savannah 31402
Morgan's
110 Ann Street
912-234-2271
HAWAII
Hilo 96720
Hawaii Planing Mill Ltd.
380 Kanoalehua Avenue
808-935-0875
Honolulu 96819
A.L. Kilgo Co., Inc.
180 Sand Island Road
808-832-2200
Honolulu 96819
Slim's Power Tools, Inc.
1626 Reputation Street
808-841-0902
Honolulu 96817
John Grinnon Co., Inc.
345 N. Nimitz Hwy.
808-538-7333
Kehululu 96732
Maui Power Tool Service
251-H2 Lalo Street
808-877-3440
IDAHO
Boise 83705
Air Equipment Company
2350 South Orchard Street
208-375-1313
Boise 83708
K. C. Supply Co.
5103 Irving Street
208-375-1313
Coeur d'Alene 83814
Coeur d'Alene Tool
451 Cherry Lane & Hwy 95
208-667-1158
Idaho Falls 83403
Rosiers Electric Motor
1501 South Capital Avenue
208-529-3665
Twin Falls 83301
Ellis Repair
2380 Kimberly Road
209-734-4400
ILLINOIS
Addison (Chicago) 60101
Porter-Cable Corporation
311 Laura Drive
708-828-6100
North Pekin 61554
Central Tool & Equip.
Div. A & I Supply
97 Highway Blvd.
309-382-2400
Springfield 62702
James Machinery
223 N. MacArthur
217-522-9115
INDIANA
Elkhart 46516
Thunander Corporation
21861 Protecta Dr.
219-295-4131
Evansville 47711
Tri State Repair Service
1327 N. Fares
812-464-9341
607-729-5287
Fort Wayne 46808
Merrick Evans Inc.
2116 W. Coliseum Blvd
219-482-4822
Goshen 48528
C & L Electric Motor Repair
1405 Chicago Avenue
219-533-2643
Indianapolis 46241
Macco Equip. Co., Inc.
3129 Kentucky Avenue
317-248-1444
Valparaiso 46383
Airmaster, Inc.
152 Appletree Lane
219-477-5495

Los Angeles 90004-5905
California Electric Service
140 S. Vermont Avenue
213-388-9651
Fax: 213-388-8577
Los Angeles 92203
Mini Tool Company
3026 E. Olympic
213-264-7006
Mission Viejo 92691-3128
California Electric Service
23725 Via Fabricante, Unit B
714-586-9440
Fax: 714-586-9514
Modesto 95351
Stanislaus Electric Mtr. Wrks.
504 River Road
209-523-8269
National City 92050
Nall Tool & Machy. Repair, Inc.
241 W. 35th St. STE D
619-422-8665
North Hollywood 91605
Bucknall Power Tool Service
11910 Vose Street
818-765-0228
Oakland 94606-4389
California Electric Service
1139 E. 12th Street
415-834-1050
Fax: 415-836-1125
Oceanside 92054
Power Source
1555 S. Hill Street
619-433-6600
Pasadena 91107-3785
California Electric Service
2594 E. Colorado Blvd.
818-792-3194
Fax: 818-792-0511
Redding 96002
Electric Tool and Motor
915 Well Street #1
916-222-1131
Sacramento 95814-6784
California Electric Service
1821 "Q" Street
916-443-5711
Fax: 916-443-4082
Sacramento 95814
Construction Industry Service
Company
1211 C Street
916-444-2525
San Carlos 94070-4168
California Electric Service
990 Industrial Road, Suite 102
415-593-6696
Fax: 415-593-6698
San Diego 92104-1593
California

Authorized Service Stations (continued)

Las Vegas 89109 Tool Service, Inc. 3229 Industrial Road 702-734-9161	Unlondale 11553 Enterprise Machinery Co., Inc. 825 Nassau Road 516-485-2804	Toledo 43606 Power Tool Sales & Service 2934 Douglas Road 419-473-0962	Mt. Pleasant 29464 Royal Ace Hardware 884 Ben Sawyer Blvd 803-884-2552	Houston 77008 Circle Saw Builders Supply 2510 Ella Boulevard 713-864-8444	WASHINGTON Renton 98055 Porter-Cable Corporation 268 Southwest 43rd Street 206-251-6880
Reno 89512 Comstock Electric 425 Eureka Avenue 702-323-5982	Ulica 13502 McQuade and Bannigan 1300 Stark Street 315-724-7119	Toledo 43613 Electric Tool & Equipment 3156 Upton Avenue 419-474-7537	Myrtle Beach 29577 Coastal Elec. & Rewinding 718 8th Avenue N 803-448-3586	Houston 77092 Porter-Cable Corporation 5201 Mitchelldale, Suite B-9 713-682-0334	Spokane 99202 Spokane Power Tool E. 801 Treni Avenue 509-489-4202
NEW HAMPSHIRE Brentwood 03833 Brentwood Machine Sales Inc. Building #313 - Rte #125 603-679-8452	Vestal 13850 Cascade Electric Inc. 416 Commerce Rd. 607-729-5278	Valley View 44125 Porter-Cable Corporation Sweet Valley Business Park Unit #18 216-447-9030	Spartanburg 29302 Cash Supply 113 Country Club Rd. 800-585-9326	Longview 75606 Eastex Welding Box 3223, 1232 W. Marshall 214-758-7327	Tacoma 98424 Tap Power Tool Service 1401 52nd Avenue, East 206-922-1803
Keene 03431 Hamshaw Lumber 3 Braddock Street 603-352-6506	Watertown 13601 McQuade & Bannigan 124 Murdock Circle 315-789-2612	West Milton 45383 Conken Equipment Co. 4950 Frederick Garland Road 513-698-3363	SOUTH DAKOTA Rapid City 57702 Stan Houston Equipment Co. 1210 Oadwood Avenue 605-348-1155	Lubbock 79405 Lubbock Electric Co. 1108 34th Street 806-744-2336	Yakima 98901 Cooper Electric Motor Service 205 S. 4th Avenue 509-452-9550
Keene 03431 Monadnock Tool Source 415 Marlboro Street 603-357-7620	NORTH CAROLINA Burlington 27215 Paynes Power Tool 2550 S. Mebane Street 919-227-1031	Youngstown 44512 Moff Master Power Tools 5228 Market Street 216-783-2130	Sioux Falls 57702 Stan Houston Equip. Co. 501 S. Marron Road 805-336-3727	San Angelo 76903 Frank's Electric 2621 Martin Luther King 915-555-8928	WEST VIRGINIA Huntington 25701 Lawter Electric Motor Co. 202 Adams Avenue 304-522-8297
Nashua 03061 Hammar Industriel 175 Amherst St P.O. Box 1209 603-882-5161	Charlotte 28209 Porter-Cable Corporation 43035 South Boulevard 704-525-4410	OKLAHOMA Oklahoma City 73126 Whitton Supply Co. 1419 W. Reno 405-236-5581	TENNESSEE Chattanooga 37412 F & D Tool Service and Supply 4121 Ringgold Road 615-898-6454	San Antonio 78205 Electric Motor Service 1514 E. Commerce 512-229-3482	Wheeling 26003 Kennedy Hardware 3300 McCulloch Street 304-233-3600
NEW JERSEY Somerville 08876 Bulenski Services Co. 10 County Line Road, Suite 7 908-707-0912	Foscoe 28604 Action Power Tools Hwy. 105 704-963-7271	Tulsa 74101 Wesche Company P.O. Box 217 2005 East 7th Place 918-583-7551	Clarksville 37043-5153 Triple S Industries 1511A Vista Lane 615-648-8665/615-648-9288	San Antonio 78212 Otto Dukes Machinery 600 San Pedro 512-224-5576	WISCONSIN Green Bay 54301 Power Tool Service Co. 310 N. Webster Ave. P.O. Box 1343 414-437-2594
Union 07083 Porter-Cable Corporation 945 Ball Avenue 201-964-1730	Greensboro 27405 Tool & Equipment Supply, Inc. 807 Huffman Street 919-275-6124	OREGON Eugene 97402 Jim's Tool Service 515 Wilson Street 515-344-1513	Jackson 38301 Smith Tool Service 908 S. Highland Avenue 901-427-4012	Sherman 75090 Texoma Tool Repair Co. 309 E. Houston Street 214-892-1510	LaCrosse 54603 A-Line Machine Tool Co. 800 Monitor St. 608-785-1515
NEW MEXICO Albuquerque 87107 Marlin Saw and Tool 3421 Vassar N.C. 505-888-1675	Raleigh 27604 Specially Tool Service of Raleigh Inc. 2420 Atlantic Ave 919-833-5903	Klamath Falls 97601 Quality Tool Repair 836 Richmond Street 503-883-5870	Jamestown 38556 Kirby's Fix-It P.O. Box 147, 120 N. Norris 615-879-7414	Tyler 75702 Mason Machinery 1908 W. Erwin Street 214-592-6581	Madison 53713 Electric Motors Unlimited 1000 Jonalinn Drive 608-271-2311
Albuquerque 87108 J-M Tool Repair Co. 320 Florida S.E. 505-255-2304	Wilmington 28405 Coastal Power Tool and Equipment Repair 1913 Carolina Beach Road 919-782-0777	Medford 97501 Precision Power Tool Repair Inc. 2919 N. Pacific Highway 503-770-5541	Knoxville 37914 Adrian Machine Tools 2900 Thorn Grove Pike 615-522-9991	Waco 76710 Gross Yowell 3720 Franklin Drive 817-754-5425	Milwaukee 53222 Porter-Cable Corporation 10700 W. Burleigh Street 414-774-3650
NEW YORK Albany 12206 Albany Burner Control, Inc. 20 Colvin Avenue 518-459-8856	Wilmington 28405 M. F. McLean Enterprises Rt. 6, Box 97 Old Wrightsville Road 919-343-1775	Portland 97202 Professional Power Tool Repair, Inc. 2506 S.E. 8th Ave. 503-234-3734	Knoxville 37918 Shop Equipment Service Co. 4821 N. Broadway 615-688-3574	Weslaco 78598 Westco Tool Co. 316 E. 4th Street 512-968-9156	Oshkosh 54901 Klit & Plet Hardware 412 North Main 414-236-3340
Amherst 14226 Phillips Bros. Supply Inc. 2525 Kensington Avenue 715-839-4800	Old Wrightsville Road 919-343-1775	Portland 97212 Continental Machine & Tool Inc. 51 N.E. Hancock 503-288-8888	Memphis 38106 Power Tools, Inc. 1200 S. Bellevue 901-774-1212	Wichita Falls 76307 Bond Tool Company P.O. Box 32 817-322-5343	Wausau 54401 R.A. Miller Supply 1169 McCleary Street 715-842-9189
Buffalo 14210 SS Electric Repair Shop Inc. 2470 Seneca Street 716-823-1232	Winston Salem 27106 Piedmont Power Mach. Srv. Inc. 4305J Enterprise Drive 919-759-2022	Redmond 97756 Dave's Tool Repair 2392 S. Highway 97 503-548-0510	Memphis 38115 Bird Fasteners, Inc. 5520 Winchester Rd., #102 901-366-1748	UTAH Logan 84321 Tool Liquidator 839 N. Main 801-753-4256	WYOMING Casper 82601 Casper Saw Shop 147 S. McKinley 307-237-3279
Commaack 11725 County Power Tool Service, Inc. 237 Commaack Rd. 516-499-5666	Portland 97212 Continental Machine & Tool Inc. 51 N.E. Hancock 503-288-8888	PENNSYLVANIA Allentown 18103 Curio Electric Repair 825 South 5th 215-432-9923	Nashville 37210 Power Tool Service of Nashville, Inc. 1106 Elm Hill Pike Suite #130 615-255-8227	Salt Lake City 84115 A.C. Tool and Service, Inc. 2990 South West Temple 801-487-4953	PUERTO RICO Sierra Bayamon 00619 B & M Electric Tool Repair Center Calle 49, Bloque 51 Casa 27 Avenue West Mein 809-787-2287
Flushing 11365 Porter-Cable Corporation 175-25 Horace Harding Expwy. 718-225-2040	Fargo 58103 Acme Electric Motor, Inc. 3401 Interstate Blvd. 701-235-8060	Bellefonte 16823 Triangle Bldg. Supply & Services 1076 E. Bishop St. 814-355-5885	Nashville 37210 Power Tool Service of Nashville, Inc. 1106 Elm Hill Pike Suite #130 615-255-8227	Salt Lake City 84115 M & M Tool and Machinery 1773 S. 300 W. (Rear) 801-485-8200	CANADA Alberta Calgary T2H 2L7 #10 6320 11th St. S.E. 403-255-3530
Glen Falls 12801 J. E. Sawyer 64-90 Glen Street 516-793-4104	Grand Forks 58201 Acme Electric Motor, Inc. 1705 13th Avenue North 701-746-8481	Harrisburg 17109 Stationary Equipment Sales & Service P.O. Box 10242 Rear 3605 Ridgeway Rd. 717-545-8043	TEXAS Arlene 79604 Arlene Lumber Co., Inc. 2025 Industrial Blvd. Amarillo 79109 Builder's Tool Service 2705 Virginia Circle 806-352-1772	VERMONT S. Burlington 05403 Burlington Tool Repair 23 San Remo Drive 802-658-4131	British Columbia Burnaby V5A 4T8 8520 Baxler Place 604-420-0102
Kingston 12401 Miron Bldg. Products, Inc. C.P.O. Box 1598 Rt. #9W North 914-336-6000	Minot 58701 Acme Electric Motor, Inc. 525 20th Avenue S.E. 701-839-2263	Kingston 18704 Total Services & Systems, Inc. 166 W. Union Street 717-287-2121	Austin 78722 Hamilton Electric Works Inc. 3900 Airport Blvd. 512-472-2428	VIRGINIA Charlottesville 22901 Allen Desper Repair Service P.O. Box 1512 1132 E. Market Street 804-293-7913	Manitoba Winnipeg R3H 0H2 1699 Dublin Avenue 204-633-9259
Peekskill 10566 Peekskill Electric Motor 13 South Broad St. 914-737-4141	Monroeville 15146 Professional Tool Service 700 Seac Road Monroeville Industrial Park 412-373-7440	Philadelphia 19107-2375 Ideal Tool & Equipment Service 140 N. 10th Street 215-925-0672	Austin 78758-5498 The Tool Box 9906A Gray Boulevard 512-838-5483	Fredericksburg 22404 Fredericksburg Hardware Co., Inc. 513 William Street 703-373-8383	Ontario Mississauga L4V 1J2 6463 Northam Drive 416-877-5330
Port Chester 10573 Pelham Tool Co. 21 Abendrough Avenue 914-937-1771	Cincinnati 45210 Cincinnati Electric Repair 2023 Elm St. 513-621-2183	Philadelphia 19154 Porter Cable Corporation 12285 McNulty Road 215-677-7800	Corpus Christi 78405 Corpus Christi Power Tool & Repair 3701 Agnes 512-883-1117	Harrisonburg 22801 Rocking R Hardware 1030 S. High Street 703-434-9967	Guelph N1H 6M7 544 Imperial Road 519-835-2840
Rensselaer 12144 R. B. Wing 83 Second Avenue 518-463-4161	Cincinnati 45245 Pro Tool Service 747 Ohio Pike 513-753-4349	Philadelphia 19107-2375 Ideal Tool & Equipment Service 140 N. 10th Street 215-925-0672	Corpus Christi 78405 Otto Dukes Machinery Co. 2588 Morgan Street 512-883-0921	Newport News 23606 National Tool Supplies 806 Middle Ground Blvd. 804-873-1115	Ottawa K2A 3X2 851 Richmond Road 613-728-1124
Rochester 14608 Jackson Saw & Knife Co. 517 State Street 716-546-7485	Columbus 43212 Columbus Hardware 944 W. 5th Avenue 614-294-8666	Philadelphia 19107-2375 Ideal Tool & Equipment Service 140 N. 10th Street 215-925-0672	Dallas 75220 Porter-Cable Corporation 10714 N. Stemmons Freeway 214-353-2956	Norfolk 23517 Bryan Electric Co., Inc. 424 West 25th Street 804-625-0378	Quebec St. Laurent (Montreal) H4N 1W2 523 Rue Deslauriers 514-336-8772
Rochester 14609 O. B. Schwarz 430 Atlantic Avenue 716-482-9282	Columbus 43214 Porter-Cable Corporation 4560 Indiana Avenue 614-283-0929	Philadelphia 19154 Porter Cable Corporation 12285 McNulty Road 215-677-7800	El Paso 79902 Schlosser Tool & Machinery 1505 Wyoming 915-544-8665	Norfolk 23502 Henry Walke Co. 1161 Ingle Side Road 804-855-0502	St. Foy G1N 4L5 Suite 202 2202 Rue Lavoisier 418-681-7305
Southampton 11956 Richards Tool and Motor Repair County Road 39 & N. Main Street 516-283-5130	Alpha (Dayton) 45301 Authorized Tool Service Co. 676 Orchard Lane P.O. Box 5 513-429-5593	York 17402 Diamond Air & Electric 2449 S. Queen St. 717-741-9592	El Paso 79905 C. L. North Co. 123 Chelsea Street 915-772-1469	Richmond 23230 Southland Power Tool Srv. 1705 Dabney Road 804-257-7348	
Syracuse 13220 Mid-State Contractors 1811 LeMayne Avenue, Box 2189 315-455-5903	Hartsville 44632 Hartsville True Value 940 W. Maple Street 216-877-3631	SOUTH CAROLINA Columbia 29203 Mann Electric Repair Co. 3600 Main Street 803-252-7777	Fl. Worth 76110 Air & Electric Tool Co., Inc. 3301 South Grove 817-921-0231	Roanoke 24013 Roanoke Armature Co. 1108 1/2 Street S E 703-345-8741	
Syracuse 13210 Syracuse Industrial Sales 713 E. Fayette Street 315-478-5751	North Canton 44720 N. Canton Repair Shop 1555 No. Main 216-499-3529	Greenville 29802 Poe Corporation P.O. Box 168 803-271-9000			

*IND. MACHINERY SERVICE



PARTS, SERVICE OR WARRANTY ASSISTANCE

All Delta Machines and accessories are manufactured to high quality standards and are serviced by a network of factory service centers and authorized service stations listed in your owner's manual. To obtain additional infor-

mation regarding your Delta quality product or to obtain parts, service or warranty assistance, please call or fax Delta's toll-free 'hotline' number.

Delta maintains a modern, efficient Parts Distribution Center, maintaining an inventory of over 15,000 parts located in Memphis, Tennessee.

Highly qualified and experienced Customer Service Representatives are standing by to assist you on weekdays from 8:00 A.M. to 5:00 P.M. Memphis time.



Memphis, TN 38118
4290 Raines Road
Phone: (901) 363-8800

HOTLINE
800-223-PART
FAX: 800-535-6488



Delta Building Trades and Home Shop Machinery Two Year Limited Warranty

Delta will repair or replace, at its expense and at its option, any Delta machine, machine part, or machine accessory which in normal use has proven to be defective in workmanship or material, provided that the customer returns the product prepaid to a Delta factory service center or authorized service station with proof of purchase of the product within two years and provides Delta with reasonable opportunity to verify the alleged defect by inspection. Delta may require that electric motors be returned prepaid to a motor manufacturer's authorized station for inspection and repair or replacement. Delta will not be responsible for any asserted defect which has resulted from normal wear, misuse, abuse or repair or alteration made or specifically authorized by anyone other than an authorized Delta service facility or representative. Under no circumstances will Delta be liable for incidental or consequential damages resulting from defective products. This warranty is Delta's sole warranty and sets forth the customer's exclusive remedy, with respect to defective products; all other warranties, express or implied, whether of merchantability, fitness for purpose, or otherwise, are expressly disclaimed by Delta.